



007100

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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U/R

SAD 12-11-26

RBW2905G00132-3G
Job Sheet 187020



Part No: RBW2905G00132-3G

Job Qty: 1 ea

Part Name: PCM Adapters, Hydraulic System Test Bench



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/26/18

Job Tracking No:

Due Date: 12/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: URF 18-766 DWG RBW2905G00132-3G REV 2 IPP REV A 18.02.15 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/14/18	0.00	0.00	Start Up Small Fab-4		MLL
110	Small Fab	1 pcs		12/14/18	0.00	0.50	Small Fab-4		MLL DAS
120	QC	1 pcs		12/14/18	0.00	0.00	QC4		38
130	Packaging	1 pcs		12/14/18	0.00	0.00	Packaging3-1		Dara P. 9-89
140	QC21-FG	1 Ea		12/14/18	0.00	0.00	QC21		21 DEC 19 2018

Part Op 110 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
Descriptions: APP-1470-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard
RBW2905G00132-3G-9 to RBW2905G00132-3G-7 foam as per DWG. 6-Glue foam to case and pack case as per DWG.

GA213

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	90-Start up Operation	5021040
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	110-Small Fab	5080735
APP-1470-E	Case	1 Ea (1 ea)	110-Small Fab	5080745
RBW2905G00132-3G-5	Bottom Foam	1 Ea (1 ea)	110-Small Fab	5080751
RBW2905G00132-3G-7	Top Foam	1 Ea (1 ea)	110-Small Fab	5080751
RBW2905G00132-3G-9	Plastic Placard	1 Ea (1 ea)	110-Small Fab	5080751
RBW2905G00232-3G	Adapter Assembly, Pcm Return Line	2 Ea (2 ea)	110-Small Fab	5080751
RBW2905G00332-3G	Adapter Assembly, Pcm Pressure Line	2 Ea (2 ea)	110-Small Fab	5080751

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RB41011	1	691	0
110-Small Fab	97524A032	4	671	0
	APP-1470-E	1	9	0
	RBW2905G00132-3G-5	1	6	0
	RBW2905G00132-3G-7	1	6	0
	RBW2905G00132-3G-9	1	4	0
	RBW2905G00232-3G	2	2	0
	RBW2905G00332-3G	2	0	0

Part Specifications

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause			FAULT CATEGORY								
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐								
Misidentified	☐	Past Due	☐	OTHER :							



Container No: S138442



Part: FBW2905G00132-3G

Job No: 187020

Serial No/Batch: S138442

Revision: 2

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 12/18/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
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	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
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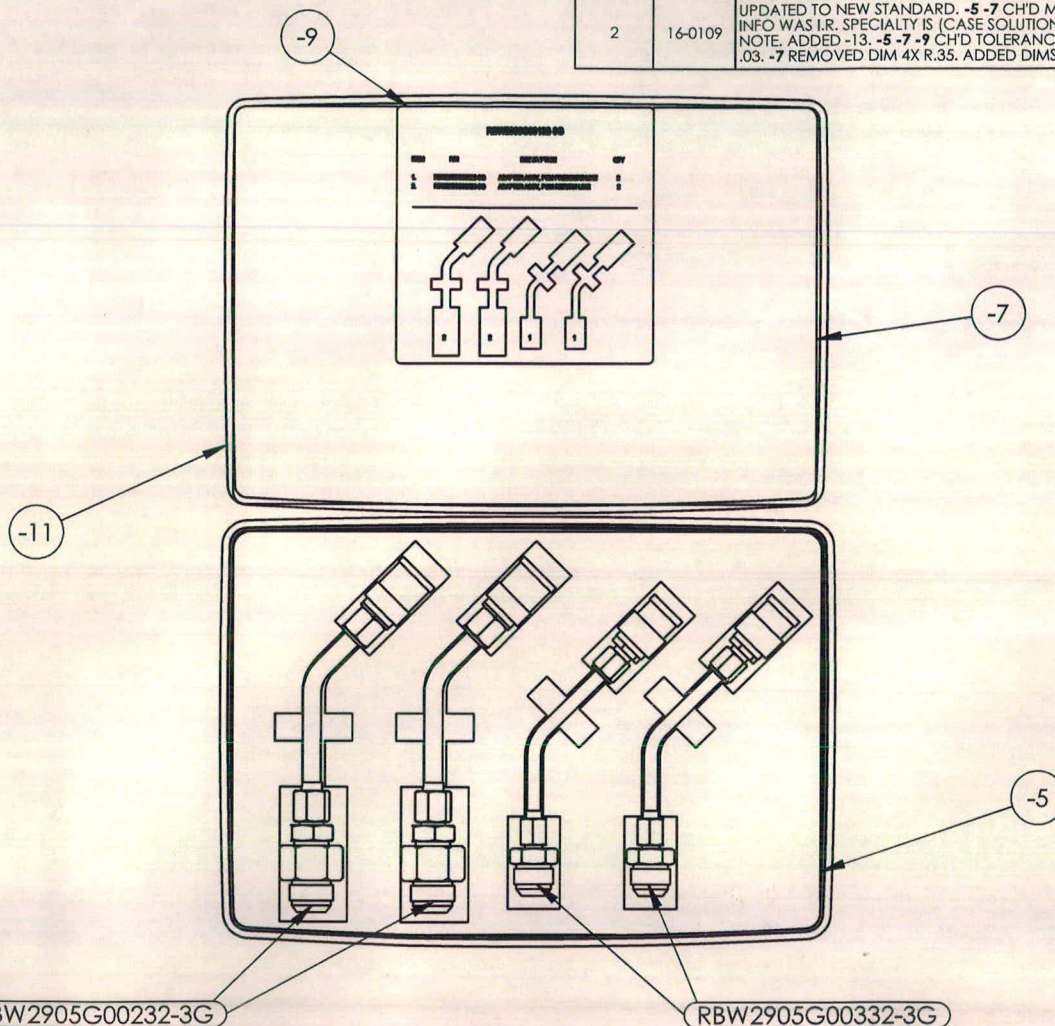
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Material	☐	Use for Testing	☐	Cuffs	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐
Past Expiry Date	☐	Manufacturing Process	☐		
Misidentified	☐	Past Due	☐	OTHER :	

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REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED
1		INCREASED FITTING CUTOUTS, FROM 2.69 TO 3.09 - FROM 3.43 TO 3.68 - FROM 2.71 TO 3.01 - FROM 2.23 TO 2.53.			5/23/2011	JAG	
2	16-0109	UPDATED TO NEW STANDARD. -5 -7 CH'D MAT'L WAS Y20 BLACK IS ETHAFOAM 220 BLACK. CH'D B/O INFO WAS I.R. SPECIALTY IS (CASE SOLUTIONS). -9 CH'D MAT'L WAS ALUMINUM IS PLASTIC. ADDED NOTE, ADDED -13. -5 -7 -9 CH'D TOLERANCES WAS .XXX ± .005 IS .XXX ± .010, WAS .XX ± .01 IS .XX ± .03. -7 REMOVED DIM 4X R.35. ADDED DIMS 4X .66, 4X 36°.			8/11/2016	DEW	JAG



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 187020 HW
1871-26

NOTE:
REF. AGUSTA T/N: 3G2905G00132.

DART AEROSPACE																							
TITLE PCM ADAPTERS KIT, HYDRAULIC SYSTEM TEST BENCH																							
DWG NO. RBW2905G00132-3G	REV 2																						
<table border="1"> <tr> <td>MAT'L</td> <td>UNLESS OTHERWISE SPECIFIED</td> </tr> <tr> <td>HEAT TREAT</td> <td>DIMENSIONS ARE IN INCHES</td> </tr> <tr> <td>FINISH</td> <td>.XXX ± .005 FRACTIONS ± 1/8</td> </tr> <tr> <td></td> <td>.XX ± .01 ANGLES ± 5°</td> </tr> <tr> <td></td> <td>.X ± .1 SURFACES = 125</td> </tr> <tr> <td>SPEC</td> <td>1. BREAK ALL SHARP EDGES .015 x 45° OR .015R</td> </tr> <tr> <td>DRAWN BY: GILBERT</td> <td>2. DIMENSIONAL LIMITS APPLY AFTER PLATING</td> </tr> <tr> <td>CHECKED: DUERFELDT</td> <td>3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009</td> </tr> <tr> <td>OPPS APPR: ANDERSON</td> <td>USED ON MODEL</td> </tr> <tr> <td>QA APPR: LINDSAY</td> <td>AGUSTA AW139</td> </tr> <tr> <td>APPROVED: GILBERT</td> <td></td> </tr> </table>		MAT'L	UNLESS OTHERWISE SPECIFIED	HEAT TREAT	DIMENSIONS ARE IN INCHES	FINISH	.XXX ± .005 FRACTIONS ± 1/8		.XX ± .01 ANGLES ± 5°		.X ± .1 SURFACES = 125	SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	DRAWN BY: GILBERT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING	CHECKED: DUERFELDT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	OPPS APPR: ANDERSON	USED ON MODEL	QA APPR: LINDSAY	AGUSTA AW139	APPROVED: GILBERT	
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APPROVED: GILBERT																							
SCALE 1:5	DATE 3/4/2011 SHEET 1 OF 4																						

ASSY QTY	ASSY QTY	B/O	Part #	QTY.	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				2	ADAPTER ASSY, PCM RETURN LINE		RBW2905G00232-3G	1
				2	ADAPTER ASSY, PCM PRESSURE LINE		RBW2905G00332-3G	1
		B/O	-5	1	BOTTOM TOOL CUSHION	ETHAFOAM 220, BLACK	16.0 X 11.0 X 2.3 (CASE SOLUTIONS)	2
		B/O	-7	1	TOP TOOL CUSHION	ETHAFOAM 220, BLACK	15.85 X 10.85 X 1.58 (CASE SOLUTIONS)	3
			-9	1	PLACARD	PLASTIC		4
		B/O	-11	1	CASE	PLASTIC	PELICAN #APP-1470-E	1
		B/O		1	DART PLACARD	ALUMINUM	RB41011	

